

Date: Wednesday, 3/26/2008 9:33:14 AM  
 User: Kim Johnston

## Process Sheet

WK15

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW KIT (19"X16")
Job Number : 38141	
Estimate Number : 12613	
P.O. Number :	Part Number : D120638011
This Issue : 3/26/2008 S.O. No. :	Drawing Number : D2435 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : MACHINED PARTS	Drawing Revision : E1
Previous Run : 30798	Material :
Written By :	Due Date : 4/10/2008 Qty: 4.91 Um: Each
Checked & Approved By : <u>JLD 08.3.26</u>	
Comment : Est Rev:A New Issue 07-01-02 JLM	

## Additional Product

Job Number:



Seq. # Machine Or Operation: Description:

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D120-638-011 CHG 002

5 0865101 08.4.15  
JLD

2.0

MUHMB10

UHMW 1" Black



Comment: Qty.: 4.6830 sf(s)/Unit Total : 18.7320 sf(s)

blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-3

Material: Black UHMW 1"

(MUHMB10)

Batch: 105862

N.A 08/04/28

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2435 Identify as D2435

3-Deburr

PTO  
→

N.A / 08/04/28

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE




Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A / 08/04/28

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D120-638-011 PAR #: N/A Fault Category: Prod/Manufactured Part NCR: Yes No DQA: D Date: 08/05/05  
QA: N/C Closed: D Date: 08/05/06

NCR: 38141		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.04.29	3	QTY (1) Cosmetic hole <del>dev</del> deviation 	RG PER Q51042 08.04.29	ACCEPTABLE DEVIATION for this one time only	H.A. 08/04/29	S 08/04/29	RG PER Q51042 08.04.29	S 08/04/29
	1.6	operator for got forget to remove the locating Bolt Belts running face mill	↓			S 08/04/29	RG	S 08/04/29

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 38141

Part Number: D120638011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/04/29

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: ~1.6660 f(s)/Unit Total: 6.6640 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 X D2182B050(5") Rubber Cushion

B35769

SQ

8.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block

37630

2 D2435(ref only) Bearpaw

2435

SQ

9.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2438 Clamp

37562

SQ

10.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer

37210

8/5/1

SQ

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
8/5/11	7.	change the quant. to <del>1.666.0 for 4 piece 1 ft 8 inches</del> 4 x D2182 B-50 (5")	SP			08/05/01	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:33:14 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 38141

Part Number: D120638011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A

Bolt

107321

SC

12.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416

Washer

107321

SC

13.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

1060251

8/5/1

(42)

SC

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

508125101 (4)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD120-638-011

Location: 17

8/5/1 (4)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/05

Job Completion



MF 08-05-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38141
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.053 x 45°	✓			
B	5.500	+/-0.030	5.497	✓			
C	0.200	+/-0.030	0.200	✓			
D	R0.250	+/-0.030	R0.250	✓			
E	0.250	+/-0.010	0.246	✓			
F	0.625	+/-0.030	0.625	✓			
G	0.25 x 45°	+/-0.030	0.252 x 45°	✓			
H	0.375	+/-0.010	0.374	✓			
I	19.000	+/-0.030	19.000	✓		tape	
J	0.950	+0.030/-0.010	0.947	✓			
K	Ø0.260	+0.005/-0.000	Ø0.260	✓			
L	Ø0.930	+/-0.030	Ø0.932	✓			
M	0.30	+0.030/-0.000	0.310	✓			
N	0.375	+/-0.030	0.375	✓			
O	7.375	+/-0.030	7.366	✓			
P	4.250	+/-0.010	4.250	✓			
Q	2.000	+/-0.030	1.996	✓			
R	9.000	+/-0.010	9.000	✓			
S	15.750	+/-0.030	15.750	✓		tape	

Measured by: <i>H.A./mf</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 08/04/28	Date: 08.04.28	Date:	

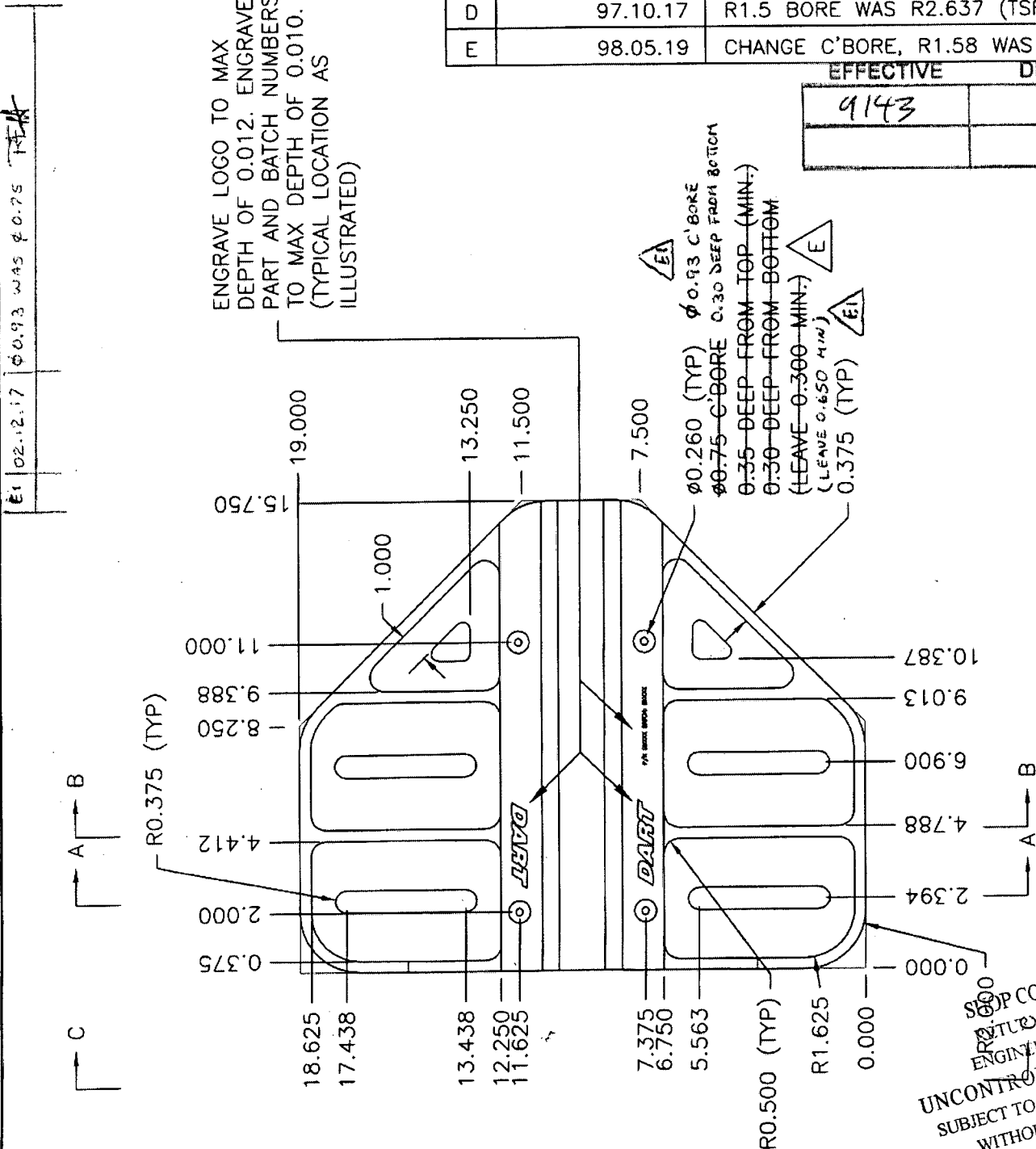
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

**DART**

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DB</i>	APPROVED <i>DB</i>	DRAWING NO. D2435	REV. E SHEET 1 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:5
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

EFFECTIVE DEOS

9143

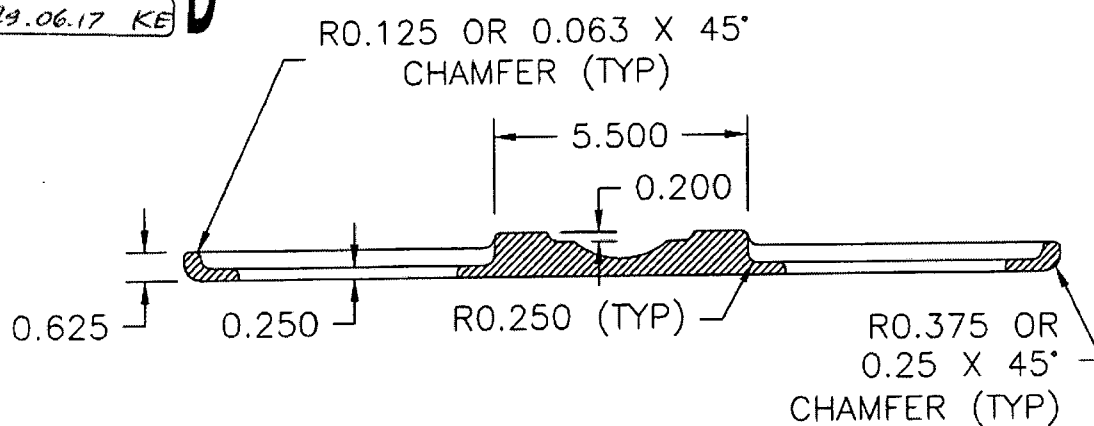
**RELEASED**  
98.06.17 *KE*ENGRAVE LOGO TO MAX  
DEPTH OF 0.012. ENGRAVE  
PART AND BATCH NUMBERS  
TO MAX DEPTH OF 0.010.  
(TYPICAL LOCATION AS  
ILLUSTRATED)STOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38411



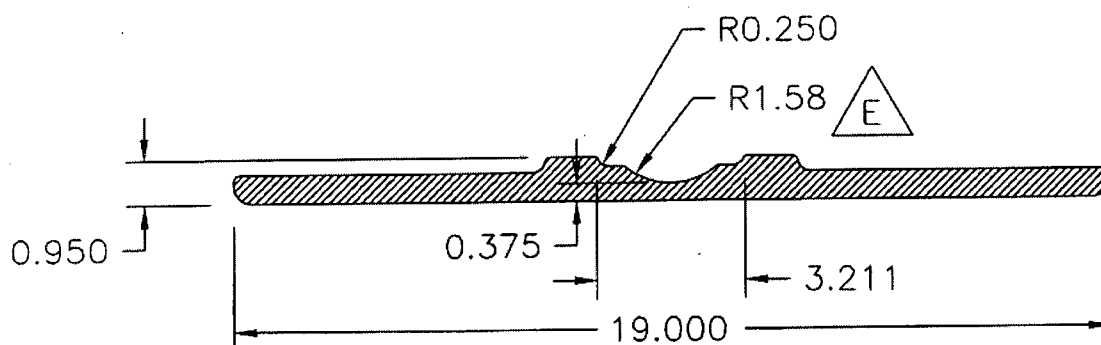


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>MB</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

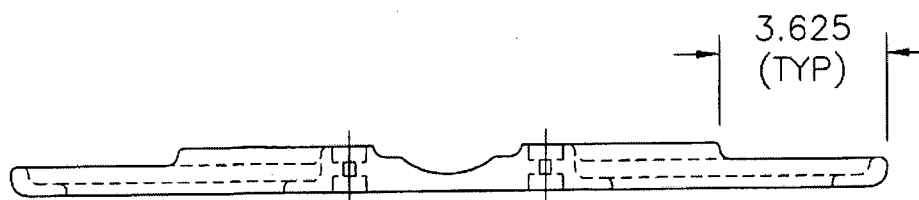
RELEASED  
99.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

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